

used in 37300

Dart Aerospace Ltd.

Date: Monday, 11/12/2007 10:51:37 AM
User: Chantal Lavoie

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP EXTRUSION
Job Number	: 35618		
Estimate Number	: 10058		
P.O. Number	: N/A	Part Number	: D2622120C
This Issue	: 11/12/2007 S.O. No. : N/A	Drawing Number	: D2622 REV C1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: C1
Previous Run	: 34694	Material	: N/A
Written By	:	Due Date	: 11/30/2007
Checked & Approved By	:	Qty:	132 Um: Each
Comment	: Est. A: [Signature] ew Issue KJ/RF		

Additional Product

Job Number

St

Description :

PURCHASING



Cc

2013

C207/10/12

as per Dwg D2622 Rev. C

Material: 6061-T6 (QQ-A-200/8)

- c) Minimum yield tensile strength = 35 ksi
- d) Minimum ultimate tensile strength = 38 ksi
- e) Minimum elongation = 8%
- f) Order at 120" longg) Bon L Canada Inc. tool # 897123 Rev. A
- h) To be packed per DSK 066
- i) Pull test to ASTM standard B221 required.
- j) Material certification is required

#10 J21

2.0 D2622120CP Extrusion

Comment: Qty.: 1.0000 Each(s)/Unit Total : 110.0000 Each(s)
Extrusion

3.0 PACKAGING 1 PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Receive & Inspect For Transit Damage
Ensure material certification is attached

4.0 QC6 DIMENSIONAL CHECK

Comment: DIMENSIONAL CHECK
Inspect dimension per Dwg D2622
Check Pull test per Dwg D2622 for compliance page attached
Check hardness with Webster testerC 211/12 B 132
S 4/10/27 (+132)

**BON L CANADA INC**500 EDWARD AVENUE
RICHMOND HILL, ON L4C 4Y9**CERTIFICATE OF COMPLIANCE**

Cart Date	Cart No	Sales Order	Page
11/23/07	169640	14251	1
Cart No	S/L No	Lot	Date
5013	00365098	14251010	11/23/07

Ship To	Ship To
DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Part No	Part No	Item Description	Cart Part
1.000	DAA-897123-1	120" Mill 6061 T6	D2622
Gross Weight	571 KGS		
Net Qty	547 KG	132 PC	402 M 2 PKG
Specification	Bin Desc		
AMS-QQ-A-200/8 & ASTM B221-00			

Mechanical Tests:

Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/ Drift HREW
1	307.6 / 44.6	277.3 / 40.2	10.5	.0	96

Chemical Analysis:

SI	FE	CU	MN	MG	CR	NI	ZN	GA	V	TI	ZR	OTHER
.66	.24	.28	.07	.92	.07	.006	.06	.000	.009	.02	.000	.00

This will certify that the material described herein has been inspected and tested in accordance with Bon L Canada's standard sampling and testing procedures or in accordance with the requirements of any specifications forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

OK #
08.02-11

D. VanBakel, QA Manager Signed for Bon L Canada

DATE _____

CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described herein, including any specifications forming a part of the description and that samples representative of the material and the inspection made and that the mechanical properties shown on the face of this sheet are:



Mark A. Yabick
Director of Manufacturing Development Works



Mark P. Young
Quality Assurance Manager

366505

66094

Ship Date

B.L. No.

Invoice No.

Alcoa No. Item

Page 1

2005-03-08

71201

89715

ECL0030-1

P.O. No./Govt Contract No.

Customer

412215 20041217

INTEGRIS-LAVAL

Ship To: INTEGRIS METALS LTD
3399 FRANCIS HUGHES
LAVAL, PQ, H7L 5A5

Item Description

122054 (M) A/T 6061-
PC COIL SHEET FOR DISTRIBUTORS TOLERANCE
GUARANTEED 2X 54806831. PER
AMS-QQ-A-250/11 & AMS4027 REV N & ASTM209 REV 04 & ASME-EN-
209 REV A99 DIMENSIONAL TOLERANCES F
ASTM35.2 REV 2003 (NOT MARKED) LIGHTLY OILED
COIL SIZES: ID 20 IN COIL WTS: MAX 7500
LB PRG WGT: 8000 LB EXPORT PACK QUAN TOL +/-
30 % CQR D152054 REV 30 CUNT REQ 05-03-
02 *** W/E 05-03-05 ***

Num	Package Ticker	Lot	Weight	Quantity	UOM	Pc Id/Serl
1	264478	335683	6362	1	PC	
2	264493	335691	6487	1	PC	
			12769	2		

Notes for CQR: D152054.30

PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ-A-250/11 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/11P. PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/11P ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/11.

CQR: D152054.30 -Specification Limits

Temp	Dir	UTS	TYS	ELAD
T6	Long Transv.	KSI	KSI	PCT
	Max			
	Min	42.0	35.0	10

Chemical Composition	SI	FE	CU	MN	MG	CR	ZN	TI	Each	Total	Aluminum
Alloy 6061	Max	.08	.7	.40	.15	1.2	.35	.25	.15	.05	.15
	Min	.40		.15		.8	.04				REMAIN

Lot: 335683 -Mechanical, Physical, Metallography, Quantometer Results

Temp	Dir	No. Test	UTS	TYS	ELAD
T6	Long Transv.	2	KSI	KSI	PCT
	Max		50.3	45	12.1
	Min		50.2	44.9	12.1

Integris Metals 8/21/2005 8:45 PAGE 003/004 FAX Server
ALCOA TUL. CANADA INC. P.O. - 76-06004 S.O. - 396551

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

Ship From: RIVERDALE, LA.

May 1961

Mark J. Yablanc
Director of Manufacturing Diversion Works

Harlan P. Young
Quality Assurance Manager

366505

66094

Shin Date

B.L. No.

Invoice No.

Alcoa No. 10000

Page 1

2005-03-08

71201

89715

ECN10030-1

P.O. No./Govt Contract No.

CUSTOMER

412215 20041217

INTEGRIS-LAVAL**Item-Description**

1-10-61 11:27 PM W. C. 152054 (M) A/T 6061-
 16 COIL SHEET FOR DISTRIBUTORS TOLERANCE
 GUARANTEED T/W 54806831. PER
 AMG-QQ-A-250/11 4MS4027 REV N & ASTM289 REV 04 & ASME-SB-
 209 REV 103 DIMENSIONAL TOLERANCES ?
 ANSIR35.2 REV 2063 (NOT MARKED) LIGHTLY OILED
 COIL SIZES: ID 20 IN COIL WGT: MAX 7500
 LB PRG WGT: 8000 LB EXPORT PACK QUAN TOL +/-
 30 & CQR B152054 REV 30 CUST REQ 45-03-
 02 *** W/E 05-01-05 ***

Notes for COR: D152054.30

Notes for CDR: D152054.30
PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ-A-250/11 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/11P. PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/11P ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/11.

COR: D152054.30 -Specification Limits

Temp	Dir	UTS	TTS	ELAD
Ft	Long Transv.	KSI	KSI	PCT
		Max		
		Min		
		42.0	35.0	10

		Min	42.0	35.0	10								Other	Other
Chemical Composition			SI	FE	CU	MN	MG	CR	ZN	TI	Each	Total	Aluminum	
	Max	.8	.7	.40	.15	1.2	.35	.25	.15	.05	.15			
Alloy 6061	Min	.40	.15		.8	.04							REMAIN	

Lot: 335683 -Mechanical, Physical, Metallography, Quantometer Results

		No.	UTS	TS	BLAD
Temp	Dir	Test	KSI	KSI	PCT
T6	Long Transv.	2	Max 50.3	45	12.1
			Min 50.2	44.9	12.1

REGIS Metals 6/21/2005 8:45 PAGE 003/004
PERSON TULL CANADA INC. P.O. - 76-06004 S.O. - 396551

8/21/2005 8:45 PAGE 003/004 FAX SERVICE